



Dart Hawkesbury
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D4635-141
Job Sheet 167079-A



Part No: D4635-141

Job Qty: 1 ea

Part Name: Fwd Ceiling Replacement Panel Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	17/12/21 19
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	17/12/21 19
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	DEC 27 2017
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4635-1 5025722	1	1	0	0
	D4669-1 5022551	2	27	0	0
	D4695-041 5022623	1	0	0	0
	D4732-29 5022550	1	5	0	0
	D4732-33 5022549	1	4	0	0
	D4732-5 5022548	1	5	0	0
	D4732-9 5022547	1	3	0	0
	D5022-1 5022526	1	4	0	0
	MPNY-750S-9-C 5022546	7	570	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		The Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Engineering ☐ Quality ☐ Other ☐	
Date: _____		Step #: _____				3 (QSI042) Approval	
Description Work Order Deviation							
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature ☐ Set-up ☐ BOM/R ☐ Broken, ☐ Inspect ☐ Contam ☐ Counte ☐ Cut Too ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Conditioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Not Correct ☐ Not Lost/Missing ☐ Not Moved ☐ Wrong wing ☐	
OTHER: _____							

DART
AEROSPACE
S025725

Fwd Ceiling Replacement Panel Assembly, LH

D4635 -- 141**Start up Operation**

Mfg Date: 12/20/17

Job No: 167079-A

PART NO:**Revision:****Operation:****Change No:**

Completed By _____

Hand / Supervisor
Approval VerificationQA Coordinator
Approval

Fit/Function	Finish
Misaligned/off center	Misread
	Turning Sequence